

# Work Order ID 50028

July 6, 2009 7:39:29 AM

*split*



Page 1

Item ID: D3826-041  
Revision ID: B  
Item Name: Rib / Gusset Assembly

Accept



Setup Start



Stop



Start Date: 08/07/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 17/07/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: *W* Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3826	Rev B

100 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- use DT9434 to assemble D2325 support gusset together  
2- locate D2325 on rib and weld as per dwg D3826 A/R ER316 S.S. Rod  
Batch: *H108160*

*PD 09.07.14  
SP 09.07.15*

110 0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

120 0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

*=> 8 02/07/16*

*Ⓢ Ⓟ*

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Page 2

July 6, 2009 7:39:29 AM

Item ID: D3826-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Rib / Gusset Assembly

Start Date: 08/07/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 17/07/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location:

*Basket cell*

Memo

0.00

0.00

*SY 09/07/16* *(4x)*

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

*09/07/16* *MF 09-07-16*

# Picklist Print

July 6, 2009 7:39:28 AM

Page 1

Work Order ID: 50028

Parent Item: D3826-041RevB

Parent Item Name: Rib / Gusset Assembly


Start Date: 08/07/2009

Required Date: 17/07/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2235-1RevB1		Manufactured	No				Each	7.0000	6.0000			
												
Basket Rib												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST ~~48665~~ B50029 — 7 ————— > 3  
48665 ————— 7 ————— > 3      SAD 09-07-10      Qty 6

D3929-041RevA                      Manufactured      No  
  
Gusset Assembly

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST                      4  
47273                      1  
48663                      3 ————— > 3      SAD 09-07-10      Qty 3  
50063 -> 3

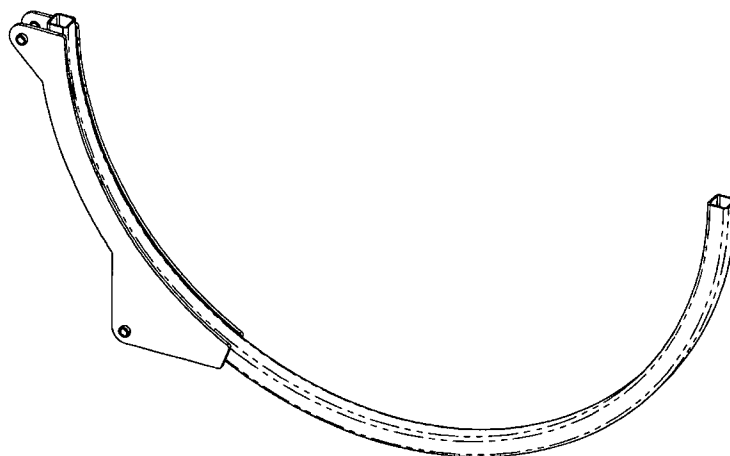
D3929-042RevA                      Manufactured      No  
  
Gusset Assembly

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST                      5  
47959                      2  
48662                      3 ————— > 3      SAD 09-07-10      Qty 3  
50062 -> 3

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY



**D3826-041 RIB/GUSSET ASSY**

50028

**RELEASED**  
8/10/12

- NOTES:**  
 1) MATERIAL: N/A  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 3.32 lbs

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.	MB	09.04.16
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.16		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

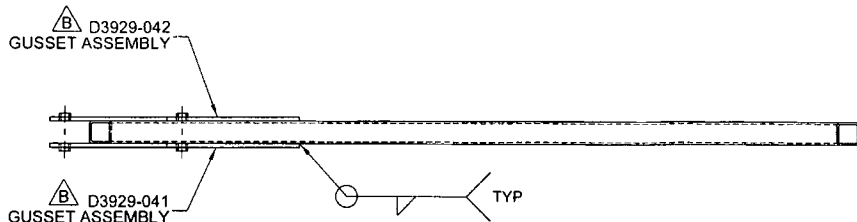
DRAWING NO. **D3826** REV. B  
 TITLE **RIB/GUSSET ASSY** SHEET 1 OF 2  
 SCALE NTS

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8 7 6 5 4 3 2 1

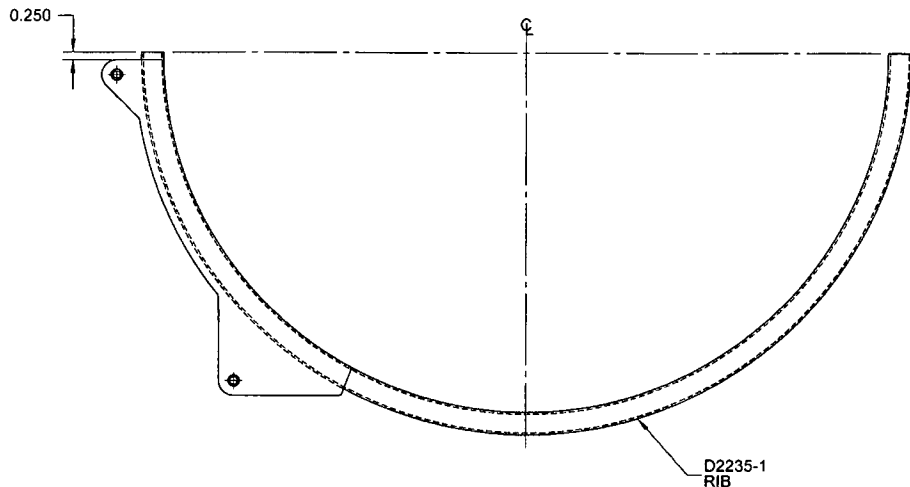
D

D



C

C



B

B

**D3826-041 RIB/GUSSET ASSY**

50028

**RELEASED**  
8/10/12-14

A

A

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3826	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		RIB/GUSSET ASSY	NTS
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8 7 6 5 4 3 2 1